

Date: Friday, 11/18/2005 6:53:16 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE SPACER
Job Number	: 24851	Part Number	: D2876
Estimate Number	: 10764	Drawing Number	: D2876 REV A
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 11/18/2005 S.O. No. : N/A	Drawing Revision	: A
Prsht Rev.	: NC	Material	: NOTE: 1 BLANK MAKES 4 PARTS
First Issue	: N/A Type : MACHINED PARTS	Due Date	: 12/21/2005 Qty: 120 Um: Each
Previous Run	: N/A		
Written By	: <u>See comment below</u>		
Checked & Approved By	: <u>See comment below</u>		
Comment	: Esr Rev:B 00.05.19 Added inspect level 8 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M5052H32S100	5052-H32 .100 Sheet
-----	--------------	---------------------



Comment: Qty.: 0.0542 sf(s)/Unit Total: 6.5016 sf(s)
 Material: 5052-H32/H34 (QQ-A-250/8) 0.100" Thick
 Batch: M15530

Ep 05/12/11 30 Blanks

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR
 1 blank makes 4 parts
 Blank: 7.00" x 4.25" (+0.030" - 0.000")

Ep 05/12/11 30 blanks

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio D2876

Ep 05/12/11 120

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Ep 05/12/11 120

5.0	QC8	SECOND CHECK
-----	-----	--------------



JL 05.12.11 120

Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/01/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 6:53:16 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 24851

Part Number: D2876

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

DL 05/12/19 120

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DL 05/12/22 120

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ML 05 12 22 120

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 384

1005/14/22 (120)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Sur 06/21/03 (120)

SP 06/01/03 (120)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

00000000

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No	:	0024851	Department Code:	
Project Name	:	D2876	Burden Flags	: NNNNNNN
Project For	:	WK550	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D2876	Invoice Number	:
Description	:	Saddle Spacer	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	120	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	11-17-05		
Est Finish Date	:	12-21-05	Est Margin	: 0.000%
Act Finish Date	:		Actual Margin	: 0.000%
Drawings Req'd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

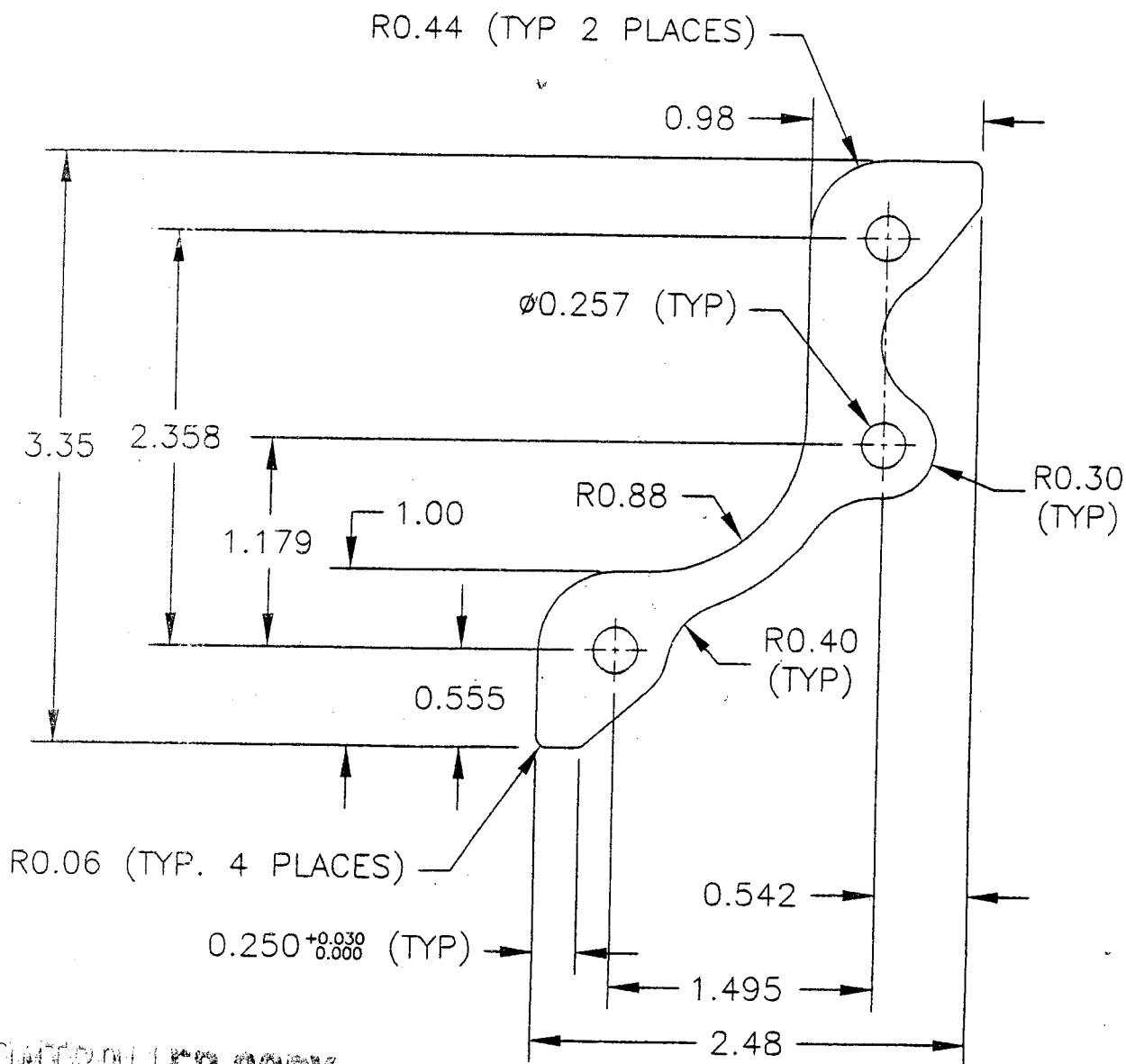
	Estimated	Actual	Var. %	Posted	To Post
=====					
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====					
Burden	: 0.00	0.00	0.00		
=====					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2876	REV. A SHEET 1 OF 1
DATE 99.02.23		TITLE SADDLE SPACER	SCALE 1:1
A	99.02.23	NEW ISSUE	

RELEASED
99.04.27 DS



CONTROLLED COPY

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.100 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL SHARP EDGES 0.010 TO 0.020

11

Measured by:		Audited by:		Prototype Approval:	
Date:		Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	